

Date: Friday, 17/08/2007 11:20:43 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
<b>Job Number</b> : 34078	
<b>Estimate Number</b> : 10939	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D29382
<b>This Issue</b> : 17/08/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2938 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 33360	<b>Material</b> : N/A
<b>Written By</b> : <u>Handwritten Signature</u>	<b>Due Date</b> : 05/09/2007 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Handwritten Signature</u>	
<b>Comment</b> : Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length <u>33496 X9</u> (D6101-003) Batch No: <u>33792 X3</u> <u>BF 07-08-31 12</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr <u>BF 07-09-01 12</u>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <u>BF 07-09-01 12</u>		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
<b>Comment:</b> INSPECT ALL DIM TO DIM SHEET <u>BF 07-09-01 12</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: AD Date: 07/09/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:20:43 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 34078

Part Number: D29382

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*mt 07/09/02 12*

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*M-h 07/09/04 12x*

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M 105088 BK 07-09-04 12*

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*C 7/9/5 (12)*

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*57429 C 7/9/5 (12)*

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 07/09/05 12*

Job Completion



*u 07-09-05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34018
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.125	.125	.125	.125		
C	0.100	0.140		.115	.115	.115	.115		
D	0.210	0.230		.223	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.551	.551	.551	.551		
P	0.490	0.510		.504	.504	.504	.504		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.746	2.746	2.746	2.746		
S	0.240	0.270		.253	.253	.253	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	BE
Date:	07.04.01

Audited by:	SM
Date:	07/08/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 34078
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	A <sub>5</sub>	A <sub>6</sub>	A <sub>7</sub>	A <sub>8</sub>		
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.125	.125	.125	.125		
C	0.100	0.140		.117	.117	.117	.117		
D	0.210	0.230		.223	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.551	.551	.551	.551		
P	0.490	0.510		.504	.504	.504	.504		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.746	2.746	2.746	2.746		
S	0.240	0.270		.253	.253	.253	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: RF
Date: 07.09.01

Audited by: [Signature]
Date: 07/09/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM [Signature]	[Signature]

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34078
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

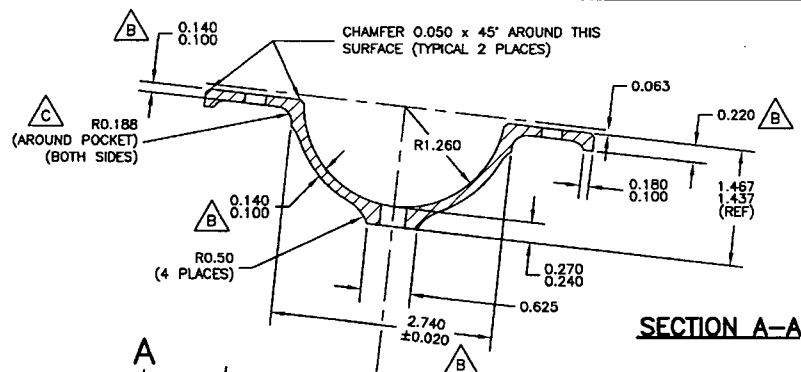
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	$\frac{1}{9}$	$\frac{2}{10}$	$\frac{3}{11}$	$\frac{4}{12}$		
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.125	.125	.125	.125		
C	0.100	0.140		.115	.115	.115	.115		
D	0.210	0.230		.223	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.551	.551	.551	.551		
P	0.490	0.510		.504	.504	.504	.504		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.746	2.746	2.746	2.746		
S	0.240	0.270		.253	.253	.253	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

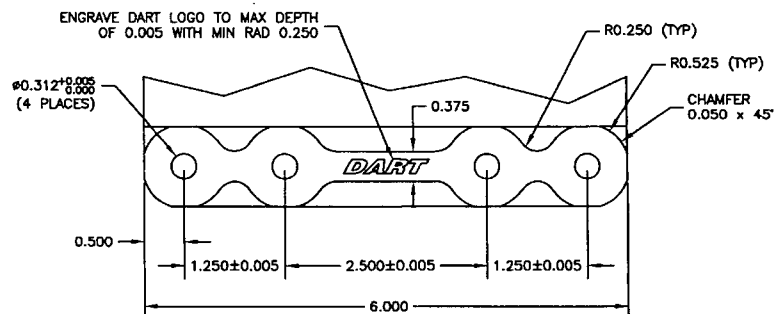
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Date:	07.09.01

Audited by:	<i>[Signature]</i>
Date:	07/09/02

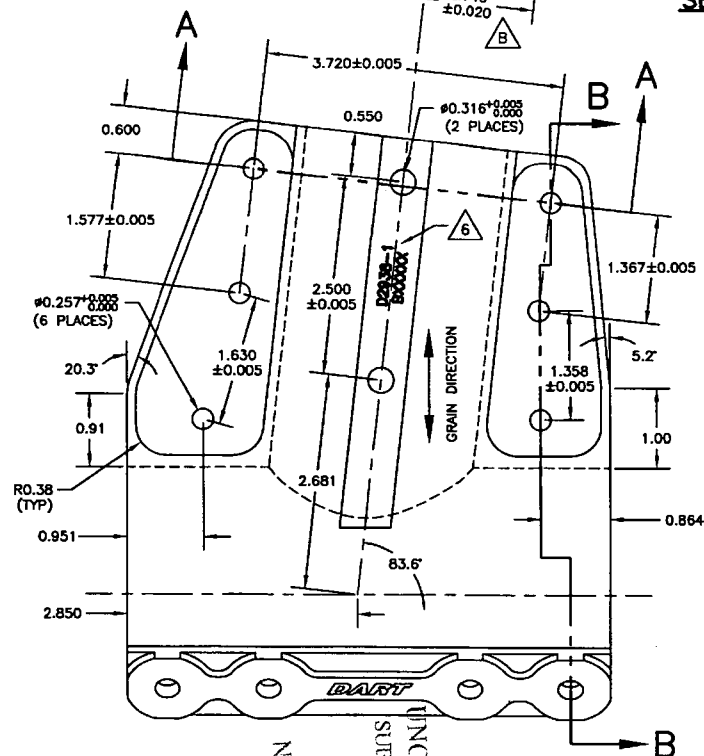
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



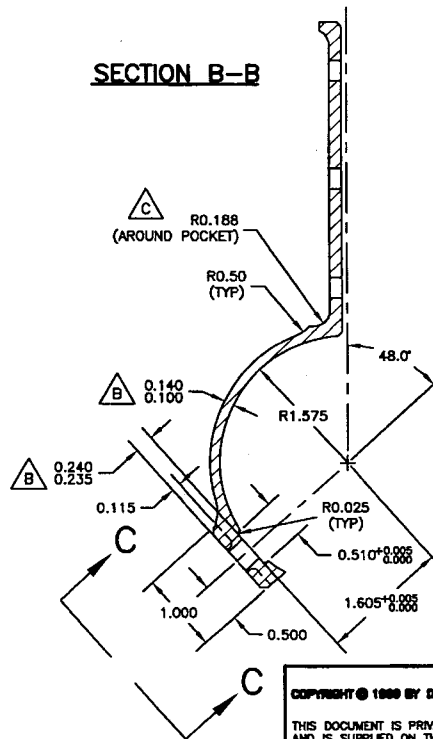
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	D2938
DATE	06.11.09	SADDLE OUTSIDE

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RELEASED

07.02.12

NO. 34078  
WORK ORDER  
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ENGINEERING  
RETURN TO  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

REV. C

SHEET 1 OF 1

SCALE

2.3